Weik Order ID 61457

Document Control

Wednesday, August 25, 2010 2:31:50 PM

BLUE

Memo



Page 1

Item ID: D206-642-441 Accept Setup Start **Revision ID:** Replacement Skidtube Item Name: Stop **Start Date:** 8/27/2010 Start Qty: 1.00 Cust Item ID: Required Date: 9/9/2010 Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: MF Date: (0 - 8-25 Tooling: Approvals: Date: Stop QC: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D2650 Rev F 0.00 DOCUMENT CONTROL

CHG002

0.00

Photocopy bluefile and create labels per PPP D206-642-441

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W/O:	,	:	. W	ORK ORDER CHANGI	ES					
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^{*} NOTE: Date & initial all entries

Item ID:

D206-642-441

Accept



Setup Start

Stop

Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/27/2010

QC:

Start Qty: 1.00

Required Date: 9/9/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

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Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

0.00

0.00

Date:

Date:

Stop

Run



Sequence ID/ Work Center ID

110



Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

Tool ID

Tool # Plan

Accept Code Qty

Reject **Qty**

Reject Number

Insp. Stamp

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use alumipum rod. Grind D2647 to fit as

A/R□□Aluminum Rod□ *Mlld20* 4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BE 10/08/26

W/O:			W	ORK ORDER CHANGE	ES			
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NOTE; Date & initial all entries

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Work Order ID 61457

Wednesday, August 25, 2010 2:31:50 PM



Page 3

Item ID:

D206-642-441

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 9/9/2010

8/27/2010

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Memo

Memo

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Accept

Qty

Run

Stop

Reject

Qty

Start



Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

115

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

5,0/08/30

0.00

116

QC Quality Control QC10- Inspect visual per QSI004- ground welds 0.00

8 0/06/30

120 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

0.00

BE 10/08/80

W/O:			WO	RK ORDER CHANG	ES			
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Work Order ID 61457

Wednesday, August 25, 2010 2:31:50 PM



Page 4

Item ID:

D206-642-441

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name: Replacement Skidtube

Start Date:

8/27/2010

Start Qty: 1.00

Req'd Qty: 1.00



Date:_____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Operation

Description

QC3- Inspect Part Finish

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run



Required Date: 9/9/2010

Sequence ID/ Work Center ID

130

QC

Memo

Set Up/ Run Hours

0.00

Tool # Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

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DATE	STEP	Section A	Initial	Action Desci	iption	Sign &	Section C	Chief Eng	QC Inspector

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Work Order ID 61457



Page 5

Insp.

Stamp

Wednesday, August 25, 2010 2:31:50 PM Item ID: D206-642-441 Accept Setup Start Revision ID: Stop Item Name: Replacement Skidtube **Start Date:** 8/27/2010 Start Qty: 1.00 Cust Item ID: Req'd Qty: 1.00 Required Date: 9/9/2010 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description Run Hours. Code Qty Qty Number 140 0.00 Skidtubes Skidtubes 0.00 Skidtubes 1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.

cure time before cutting

Start Date: ✓ Time: □ ✓

Finish Date: 18/8/3/

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W/O:			WORK ORDER CHAN	IGES 🏸				
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Work Order ID 61457

Wednesday, August 25, 2010 2:31:50 PM



Page 6

Item ID:

D206-642-441

Accept



Setup Start

Stop

Start



Revision ID:

Item Name:

Required Date: 9/9/2010

Replacement Skidtube

Start Date:

8/27/2010

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Date: Tooling:

Date:

Tool # Plan

Code

Stop



Sequence ID/

Work Center ID

150

QC

Quality Control

Operation **Description**

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

SPC (Y/N):

Tool ID

Date:

Accept Qty

Reject Qty

Run

Reject Number

Stamp

Memo

0.00

160

Skidtubes Skidtubes

Skidtubes

0.00

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the

other side. Use aluminum rod. A/R Aluminum Rod M1850

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburg

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Work Order ID 61457

Wednesday, August 25, 2010 2:31:50 PM



Page 7

Insp.

Stamp

Item ID: D206-642-441 Accept Setup Start **Revision ID:** Stop Replacement Skidtube Item Name: **Start Date:** 8/27/2010 Start Qty: 1.00 **Cust Item ID: Req'd Qty:** 1.00 Required Date: 9/9/2010 **Customer:** Reference: Start Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: Stop QC: _____ Date: ___ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject **Work Center ID** Description **Run Hours** Qty Qty Code Number 170 0.00 HandFinishing Skidtubes 0.00 BE 10/09/07 Memo Skidtubes Install D2680-041 Nut Plate as per Dwg D2650 180 QC10- Inspect visual per QSI004- ground welds QC Memo Quality Control

190



Quality Control



QC5- Inspect part completeness to step on W/O

Memo

30/PG/01 2 00.0

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W/O:			W	ORK ORDER CHANG	GES				'*	
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Page 8

Wednesday, August 25, 2010 2:31:50 PM

Item ID:

D206-642-441

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/27/2010

Start Qty: 1.00

Required Date: 9/9/2010

Req'd Qty: 1.00



Date: _____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date: _____ Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/

Work Center ID

200

HandFinish

Hand Finishing

Operation Description

Pressure Wash per QSI005 4.3

Set Up/ **Run Hours**

0.00

10/08/16

Qty

Accept

Memo

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in

205

SprayPaint **Spray Painting** Memo

0.00

0.00

Spray paint Delfleet Blue Primer B 1144 Q4 Delfleet Blue B 11317

Clear Delfleet B 115506

206

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

ZT 10-09-24

W/O:			W	ORK ORDER CHANGE	S				
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Work Order ID 61457

Wednesday, August 25, 2010 2:31:50 PM



Page 9

Item ID:

D206-642-441

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/27/2010

Start Oty: 1.00

Required Date: 9/9/2010

Req'd Oty: 1.00



Cust Item ID: Customer:

Reference:

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QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

Date:

Tool # Plan

Code

Date:

Start Run



Insp.

Stamp

Sequence ID/ **Work Center ID**

230



HandFinish

Hand Finishing

Oper	at	ion	
)esc	rip	tio	n

HandFinishing

Set Up/ **Run Hours**

10/09/27

Tool ID

Accept

Qty

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

—A/R□Sikaflex-291□1/1 14 09 3□ Sikaflex expiry date: ☐ 10 10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R□□Sikaflex-291□△√√↓↓↓↓ ○ ⑤ ⑤ Sikaflex expiry date: 10110

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 \square Batch: 105028

Stop

Reject

Number

Reject

Qty

W/O:			WO	RK ORDER CHANG	ES				
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Work Order ID 61457

Wednesday, August 25, 2010 2:31:50 PM



Page 10

Item ID:

D206-642-441

Accept

Setup Start

Stop



Revision ID:

Item Name: Replacement Skidtube

Start Date:

8/27/2010

Start Qty: 1.00

Req'd Qty: 1.00 Required Date: 9/9/2010

Date:_____

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Date:

Tool # Plan

Code

Start



Sequence ID/ Work Center ID

240

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00

Run

Reject

Qty

Stop

Reject

Number Stamp

Insp.

250

Packaging

Packaging

Memo

Memo

0.00

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location:

PPP Rev:____

260

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/2898) MF 9-28

Accept

Qty

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Picklist Print

Wednesday, August 25, 2010 2:31:49 PM

Work Order ID: 61457

Parent Item:

D206-642-441

Parent Item Name:

Replacement Skidtube

Start Date: 8/27/2010

Start Qty: 1.00

Required Date: 9/9/2010

Page 1

Required Qty: 1.00

Comments:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	4.0000	1	1			
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					57542		4		<u></u>		#	EIOP	08/27
D2646		Manufactured	No			110	Each	72.0000	1	1			,
Aft Cap						•				M.	0109	27	08/27
				Location	<u>l</u>	Loc	<u>Qty</u>	Loc Code					
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					57332		63				· .		
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D2647			N. 1		52663		9		_	_X(-		
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D2654-7 H aa ha a inia hoid a hah ahii a hah mada	11 † 18 3	Manufactured	No			160	Each	3.0000	1	1 .	U .0	19090	,
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W/O:		WORK ORDER CHANGES								
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	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)								
	DATE STEP Description of NC Section A	Description of NC		Corrective Action Section B	1.01/4-1	Verification	Approval	Approval			
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Wednesday, August 25, 2010 2:31:49 PM

Work Order ID: 61457

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

112314 113539

113973

Location

ST311

170

Each 472.0000

2

Cherry Rivet

D2649

Manufactured

Manufactured

No

No

Loc Otv 472 44 424 170

Each

29.0000

Loc Code

23

Cross Bolt Spacer

D2680-041

Nut Plate

No

Location Loc Oty LG 29 58545 2 60652 27 170 Each

35.0000

Loc Code

Location ST021

55366

Loc Qty 35 35 Loc Code

____ BB 10/09/07

W/O:			WC	RK ORDER CHANG	ES				•
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NCI	₹) .			• 1
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Wednesday, August 25, 2010 2:31:49 PM

Work Order ID: 61457 Parent Item: D206-642-441				
Parent Item Name: Replacement Skidtube			Start Date: 8 Start Qty: 1	•
ALS4-1032-130 Purchased	No	230 Each	3,222.000 60	H 10/04/27
	Location PKG11 (114723) ST282 110511 114407 ST381	Loc Qty 3030 3030 153 10 143 39	Loc Code	
Washer WAS1149D03321 Purchased Washer WAS1149C03321 Purchased Washer WAS1149C03321 Purchased Washer WAS1149C033212	No * * * * * * * * * * * * * * * * * * *	230 Each 2 36 5 7 2 X Z Loc Oty 2501 2501	2,501.000 62	62 10 69 27
AN960JD416 (NAS1149D04631) Purchased Washer	No	230 Each	0.0000 1	1 x / x / (0/09/27
CR3212-4-03 Purchased Cherry Rivet .	No	230 Each	1,912.000 2	2
	Location ST311 111359 112314 114436 114450 114859	Loc Oty 1912 5 2 448 83 1374	Loc Code	======================================

W/O:61	451	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mg	Approval QC Inspector		
10/08/27	230	DE NAS1149 CU33ZR Oty C60) FOR WEARSHOES BHAMILIS 698 Chyx Dem cho (need to update IIN)	199	10/09/27	60	10.69.27			
10/14/27	250			10.00.00		p. 69.27 OSI 042			

Part No: 0206-642-441 PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)							
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NOTE: Date & initial all entries

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Wednesday, August 25, 2010 2:31:49 PM

Work Order ID: 61457 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube Start Date: 8/27/2010 Required Date: 9/9/2010 Start Qty: 1.00 Required Qty: 1.00 D2651-1 Manufactured No 230 Each 734.0000 Plug Location Loc Qty Loc Code FP 152 51530 152 fpa 582 XTL (53349 411 171 D2651-3 Manufactured 230 Each 342.0000 No 22 22 10/69/27 O-Ring 1.2 Location Loc Qty Loc Code FΡ 342 V77 342 D3535-15 Each Manufactured No 230 20.0000 Wearshoe Location Loc Qty Loc Code FP18 20 7 61241 13 D3535-23 Manufactured 230 No Each 7.0000 Wearshoe Location Loc Qty Loc Code FP21

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date: _			
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Wednesday, August 25, 2010 2:31:49 PM

Page 5

Work Order ID: 61457 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube **Start Date: 8/27/2010** Required Date: 9/9/2010 Required Qty: 1.00 Start Qty: 1.00 D3535-37 Manufactured No 230 Each 17.0000 MI 10104127 Wearshoe Location Loc Oty Loc Code FP 17 56101 13 D3536-15 Manufactured No 230 Each 22.0000 Gasket Location Loc Qty Loc Code FP . 16 56055 12 FP11 59238 D3536-23 Manufactured No 230 Each 10.0000 Gasket Location Loc Qty Loc Code FP011 10 60234 10 D3536-37 230 Manufactured No 15.0000 Each Gasket Location Loc Qty Loc Code FP 15 56102 15

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W/O:		WORK ORDER CHANGES									
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		Description of NC Corrective Action Section B				Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			

Wednesday, August 25, 2010 2:31:49 PM

Work Order ID: 61457 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Wearpad

Manufactured No

Manufactured

230 Each 32.0000

Hl 10/09/27

No

No

FP 55465 FP017 48 FP17 31 57713 3 60192 3 60491 25 230 Each

Loc Qty Loc Code B61640 10.0000

10/04/27

Wearpad

MS27039-1-08

D3537-3

Location FP19

Location

Loc Qty 10 10 230 Each

1,685.000

Loc Code

Purchased Screw

> Location ST291

114718 115108

Loc Code

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Wednesday, August 25, 2010 2:31:49 PM

Page 7

Work Order ID: 61457

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube

MS27039-4-06

Purchased

No

No

Screw

MS27039C1-08

Purchased



SCREW



230

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

118.0000

Location Loc Qty Loc Code ST292 118 XI 09061 24 94 230 Each 802.0000 60

Each

Location Loc Qty Loc Code FP 801 V60 (115336) 801 ST293 19185

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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QTY QTY QTY QTY PART NUMBER DESCRIPTION D2650-1 х SKIDTUBE ASSEMBLY D2650-3 х SKIDTUBE ASSEMBLY X D2650-5 SKIDTUBE ASSEMBLY X D2650-7 SKIDTUBE ASSEMBLY D D2600-1-160 EXTRUSION D2654-1 WEB 1 D2654-3 WEB D2654-5 WEB D2654-7 WEB D2646 AFT CAP D2647 CAP 1 1 17 18 19 23 D2649 CROSS BOLT SPACER 16 18 14 22 D2651-1 PLUG 16 18 14 22 D2651-3 O-RING 1 D2680-041 NUT PLATE С 2 2 D3286-1 DOUBLER 2 2 D3286-3 STUD 42 44 54 60 ALS7-1032-130 INSERT (or AKS4-1032-130, ALS4-1032-130. ALS7-1032-130) 2 2 2 2 AN960JD10L WASHER 2 2 2 2 CCR264SS3-3 RIVET 2 2 2 2 CR3212-4-03 RIVET 2 2 2 2 MS27039-1-08 SCREW 1 1 MS27039-4-06 SCREW 1 AN960JD416 WASHER 52 52 CR3212-4-04 RIVET В /F` NOTES: DRAWING UPDATED TO CURRENT STANDARDS, SHT 1) MATÉRIAL: N/A 6 ADDED, ALL SECTION AND DETAIL VIEWS 2) FINISH: -CHEMICAL CONVERSION COAT PER DART OSI 005.4.1 TRANSFERED TO SHT 6, SHT 1 IN PL PART D2649 QTY 08.08.08 -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS -BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DELETED FROM NOTE 7 (SEE NCR 239). DART QSI 005 4.4 RMOVE CBORE, CHG DRILL, ADD CHAMFER CP 06.03.30 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED REDRAW; INCORP. DE09136/9153/9163 CP 04.05.17 4) UNITS: INCHES UNLESS OTHERWISE NOTED MOD GROUND HANDLING ON D2650-1/-3 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX С CHANGE HOLE PATTERN AND FRONT END DS 97.10.29 6) IDENTIFICATION: NONE AS MANUFACTURED CHANGES В DS 97.06.26 7) WEIGHT: N/A NEW ISSUE Α DS 97.03.25 8) WELD PER DART QSI 004 REV. DESCRIPTION BY DATE 9) DAMAGE TOLERANCE ON FWD BEND: DADT AEDOSDACE USA INC THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE. 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

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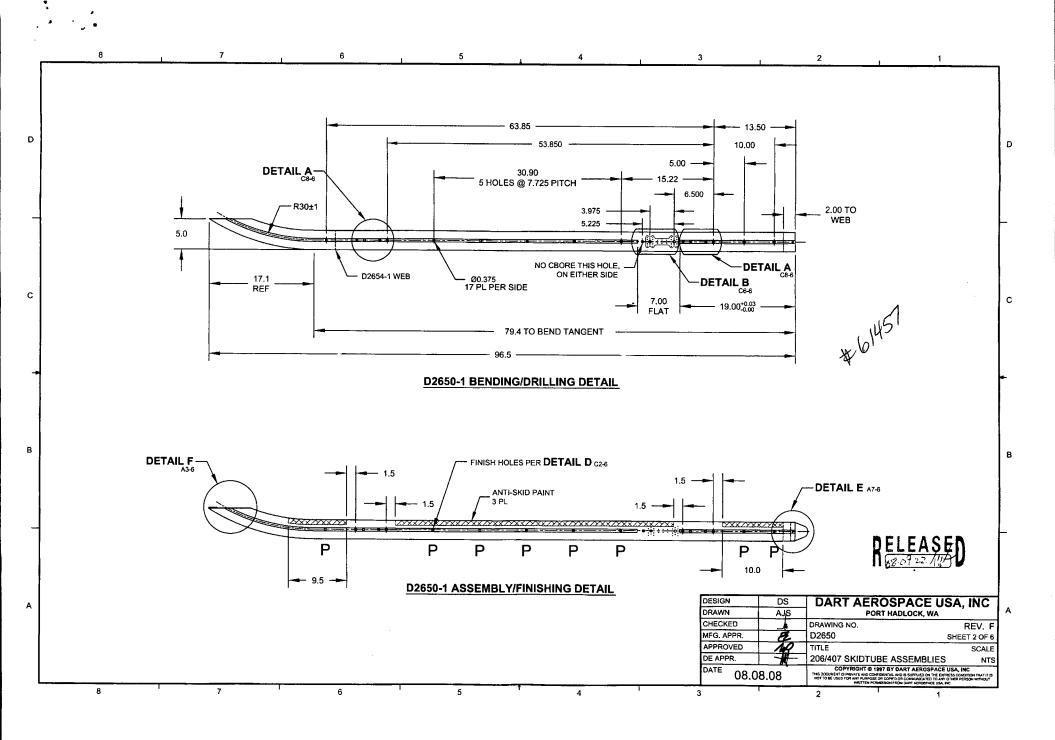
13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED		DRAWING NO.	REV. F			
MFG. APPR.	E	D2650 s	HEET 1 OF 6			
APPROVED 10		TITLE	SCALE			
DE APPR.	-	206/407 SKIDTUBE ASSEMBLIES				
DATE 08.0	8.08	COPYRIGHT © 1997 BY DART AEROSPACE U	SA, INC S CONSTION THAT IT IS			

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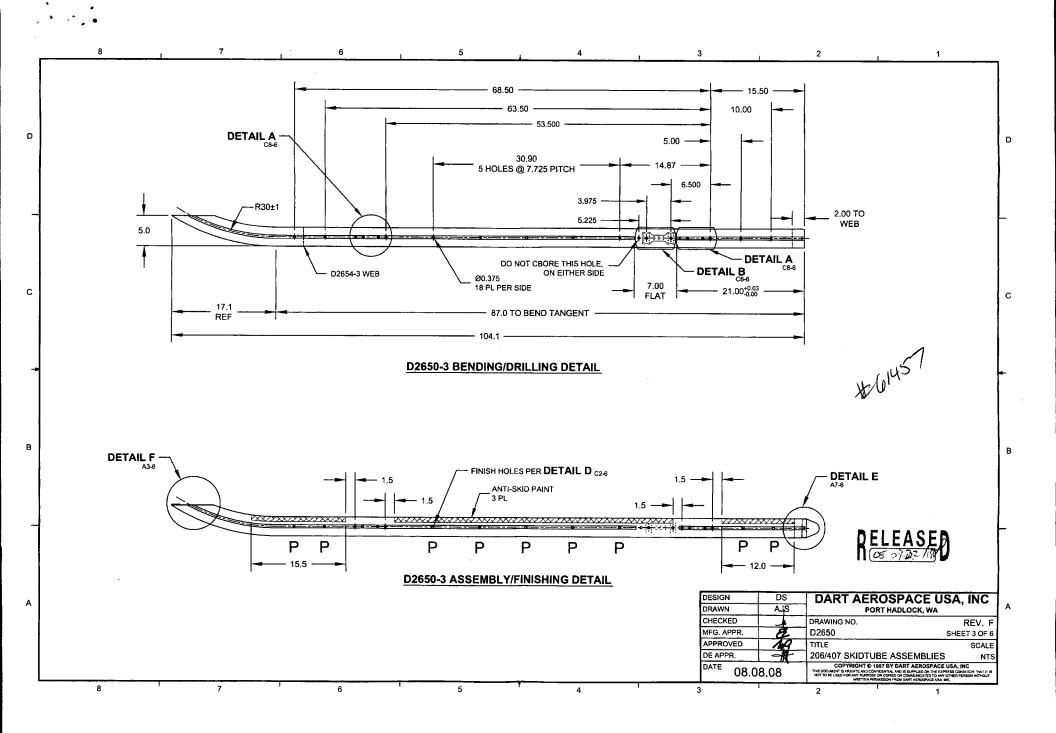
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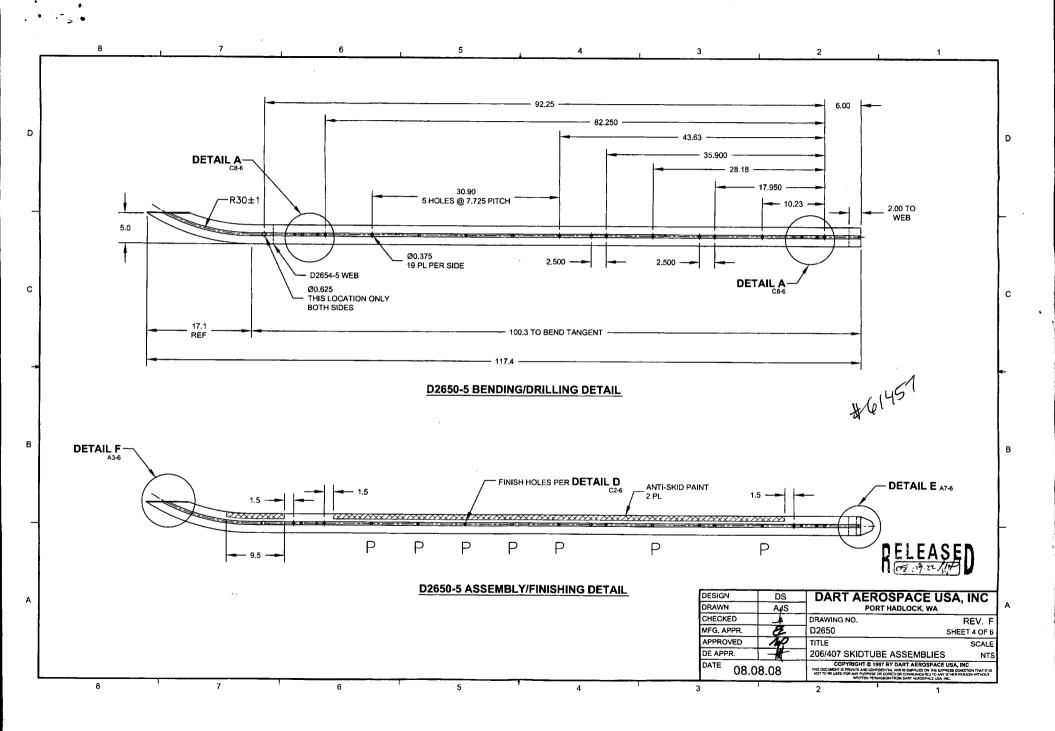


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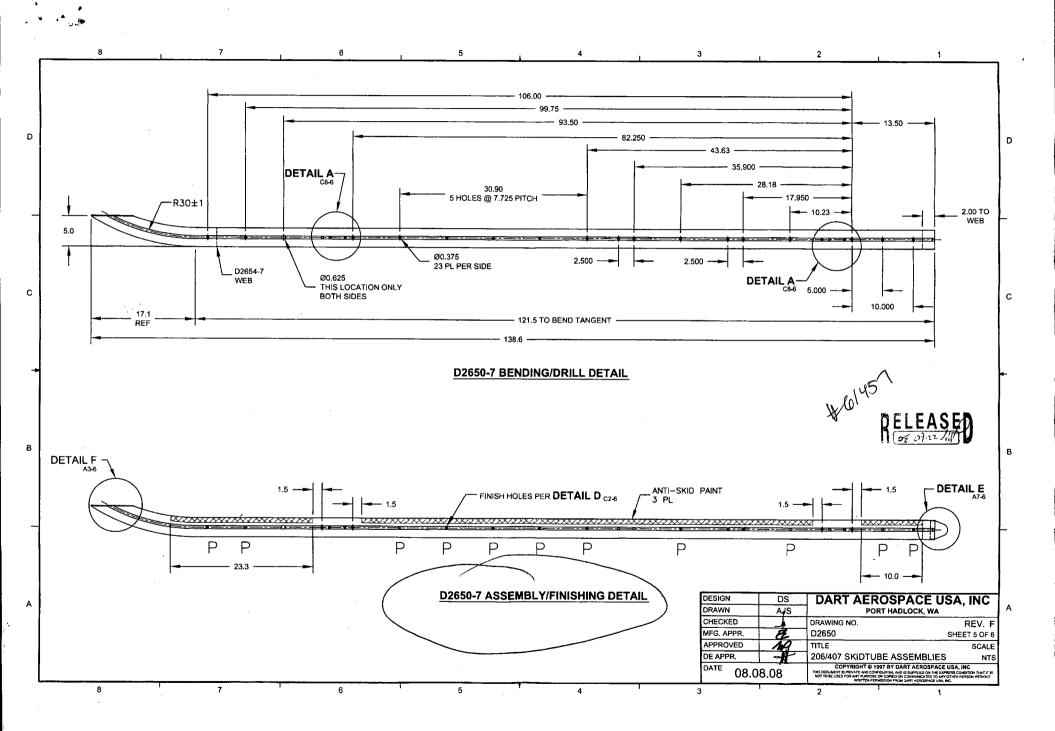


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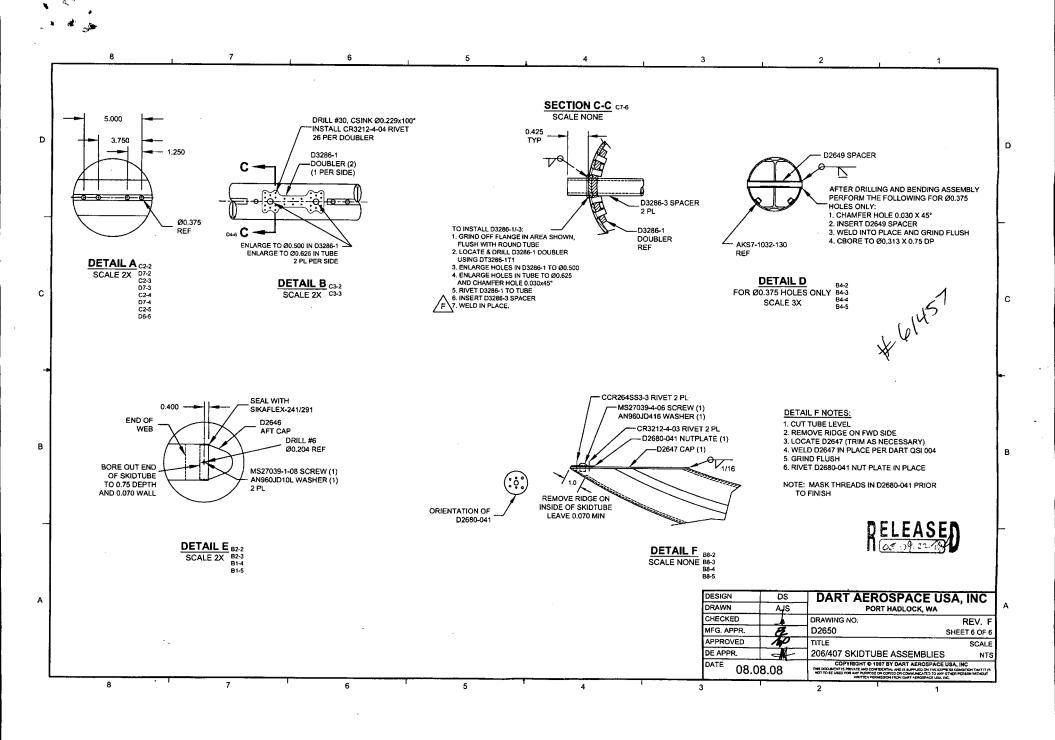
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: forclas Elliott
Job number: 6039
Part number: Daco HID - 441
Description: Dolo Skid tube
Welding Process: Tig[/] Mig[]
Base materiel: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Del Del Welder Bootlay Elliat	Date of Test Coupon 10 08 19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld